



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE-350DAMPER Job Sheet 197508



Part No: RBE-350DAMPER

Job Qty: 12 pcs

Part Name: Damper Spanner Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/10/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE-350DAMPER REV:1 IPP REV:A 18.01.16 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Large Fab - Welded Assy-1	12 pcs	9/2/19		0.00	3.00	Large Fab - 1		MV Nov 14/19
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
100	QC 5	12 pcs	9/2/19		0.00	0.00	QC 5 - 10		B
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S231747



RBE - 350DAMPER

Job No: 197508

Serial No/Batch: S231747

Revision: Rev 1

Sector:

Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON K6A
CANADA
TEL: 1 613 632-5200
Email: sales@dartae
www.dartaerospace.com

110 QC 9	12 pcs	9/2/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	12
				QC 9 - 9	
115 Handfinish -7-1-BeadBlast-B4B	12 pcs	9/2/19	0.00 3.00	Handfinish - 7 - 1 - B4B	12 19-11-18
				Handfinish - 7 - 2 - B4B	
120 Outsource - 12 - Black Oxide	12 pcs	9/2/19		GRO002-VC 10	2019-11-22
125 Packaging 2-1 - Receive - B4B	12 pcs	9/2/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP NOV 28 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
126 QC 6	12 pcs	9/2/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	DEC 11 2019 68
				QC 6 - 61	9-89
				QC 6 - 40	
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	12 pcs	9/2/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	BA144A
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Plex 7/10/19 7:43 AM Dart.lajeunesse.mari	

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
500 QC 21 - FG	12 pcs	9/2/19	0.00 0.00	QC 21 - FG - 21 ✓	DAS GA144A
				QC 21 - FG - 70	21
				QC 21 - SA - 53	DEC 1 2 2019
Part Op 95 - (Weld per dwg A/R Steel rod Batch: <u>M138946</u> , WELD AS PER DWG Descriptions: 100 - (QC5- Inspect part completeness to step on W/O) 110 - (QC9- Inspect visual per QSI004- Fusion Welds) 120 - -Issue P/O; PO <u>45162</u> -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required 125 - (Receive & Inspect for Damage & Mat'l Certs) 126 - (QC6- All purchased or subcontracted products) 130 - (Identify as per dwg & Stock Location: _____), Identify and Stock 500 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
RBE-350DAMPER-03	Adjustable spanner	12 pcs (1 ea)	95-Large Fab - Welded Assy-1	<u>5202136</u>	
RBE-350DAMPER-05	Pin	24 pcs (2 ea)	95-Large Fab - Welded Assy-1	<u>5201833</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
95-Large Fab - Welded Assy-1	RBE-350DAMPER-03	12	8 32 ✓	0	
	RBE-350DAMPER-05	24	1 49 ✓	0	
Part Specifications					
Specifications could not be found.					

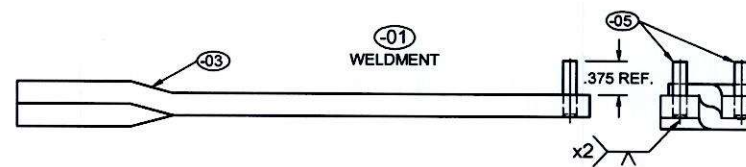
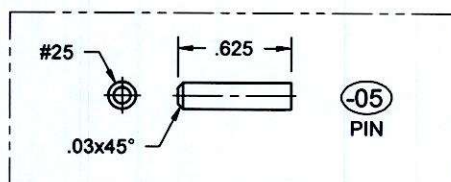
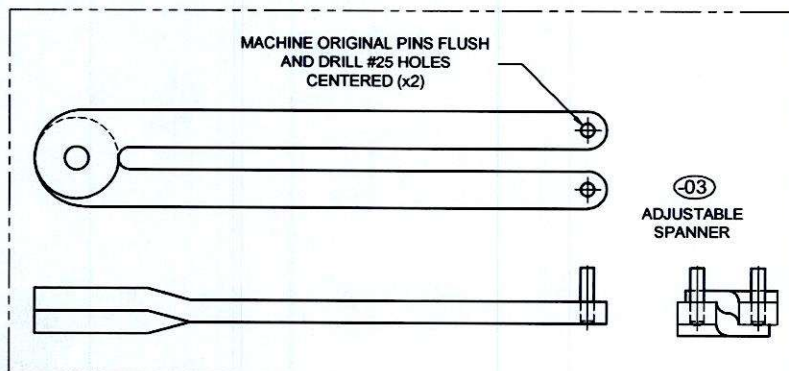
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL / APPROVED
1	DESIGNED PER HELI PRODUCTS TOOLS.	9/9/09	WP DW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 197508 HW
190710



FUNCTION: USED TO REMOVE DAMPER CAP

RED BARN MACHINE	
TITLE DAMPER SPANNER WRENCH	
DWG NO. RBE-350DAMPER	
REV 1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 XX ± .01 X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT APPROVED: <i>D. West</i> HEAT TREAT: BLACK OXIDE FINISH SPEC: USED ON MODEL EUROCOPTER AS350/355	
SCALE: NTS	DATE: 9-9-09 SHEET: 1 of 1

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
	1	MACH	-01	1	WELDMENT		
	1	MACH	-03		ADJUSTABLE SPANNER	FORGED STEEL	MCHASTER-CARR #5481A1
	2	MACH	-05		PIN	DRILL ROD	#25 MCHASTER-CARR #3009A237
ASSY	-01						

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045162



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045162

PO Date: 11/20/19

Due Date: 11/28/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-22

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201020	RBE117-15004W6-17	RBE117-15004W6 Rev B	Ring -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required	Firmed	-	11/28/19	7 pcs	0 pcs	7 pcs	\$4.25/pcs	\$29.75

X7

NOV 28 2019

DP



Dart Aerospace Ltd.
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K6A 1K7
Canada

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PURCHASE ORDER

POHB045162



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	200893	RBE105-14181W4-11	RBE105-14181W4 Rev C	Puller -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/28/19	5 pcs	0 pcs	5 pcs	\$5.50/pcs	\$27.50
3	200363	RB500N9506-1M-1	RB500N9506-1M Rev 5	Nut Socket -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/28/19	5 pcs	0 pcs	5 pcs	\$6.15/pcs	\$30.75



Grand Total: \$155.70

https://www.plexonline.com/74e38457-f1d8-49d0-a4ac-a7cf74b3c497/Plexus_Control/Report_View_2.asp?rv=u%1E..%2FPurchasing%2FPO_Print.... 3/3



Certificat de Conformité / Certificate of Compliance



0 2 4 3 1 0 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9

Tel: 514-335-3666

Fax: 514-335-3868

www.groupaltech.com

Bon de Livraison / Packing Slip

024310 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
27-Nov-2019		Karan Singh				POHB045162			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NG NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE117-15004W6-17 Rev.B	RBE117-15004W6 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309, TYPE - 3 OR MILL - C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS OIL		OXIDE-BLACK CH	7	7	0	0	0
3	RB500N9506-1M-1 Rev.5	RB500N9506-1M OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309, TYPE - 3 OR MILL - C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS OIL		OXIDE-BLACK CH	5	5	0	0	0
4	RBE117-15004W6-15 Rev.B	RBE117-15004W6 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309, TYPE - 3 OR MILL - C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS OIL		OXIDE-BLACK CH	7	7	0	0	0
5	RBE-350DAMPER Rev.1	RBE-350DAMPER 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1		OXIDE-BLACK CH	11	11	0	0	0
6	RBE-350DAMPER Rev.1	RBE-350DAMPER 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1		OXIDE-BLACK CH	12	12	0	0	0

Notes Additionnelles / Additional Notes

RECEIVED

NOV 28 2019

DART AEROSPACE LTD.

Epaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.